

Date: Thursday, 04/12/2008 9:10:49 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 43900	
Estimate Number : 10725	
P.O. Number :	Part Number : D2652
This Issue : 04/12/2008 S.O. No. :	Drawing Number : D2652 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 43804	Material :
Written By :	Due Date : 21/12/2008 Qty: 200 Um: Each
Checked & Approved By : <u>JUD 08.12.05</u>	
Comment : Est Rev:B 02.06.13 Now machined in house. NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M303R0500	303 Round Bar 0.500"
-----	-----------	----------------------



Comment: Qty.: 0.0578 f(s)/Unit Total : 11.5500 f(s)
 Material: 303 ss .500" Round Bar
 (M303R0500)
 Batch: 110252

PA 08/12/23
PA 08/12/16

(212)

(227)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

FOLIO REV: AA
 DWG REV: A

2-DEBURR AS REQUIRED

PA 08/12/23
PA 08/12/16

(212)

(227)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

PA 08/12/23
PA 08/12/16

(212)

(227)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SL 08/12/23

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1


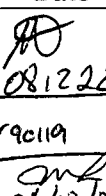
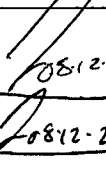


Identify and Stock
 Location: 5140

PA 08/12/24 (212)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-22	2.0	131 parts are unacceptable. over tolerance by 0.002-50.004, causing them to be very tight upon installation. Rec Test wave out during operation, i offset was not re-done.		parts are unacceptable to ship to customer, Give to Eng. Lab for noisy set-ups. Review tool calibration to ensure tool is still within spec Replaced Qty 131 M110252	 08/12/22 per qc 119 08/12/22	 08/12/22 08/12/22	 08/12/22	 08/12/22

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 9:10:49 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 43900

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

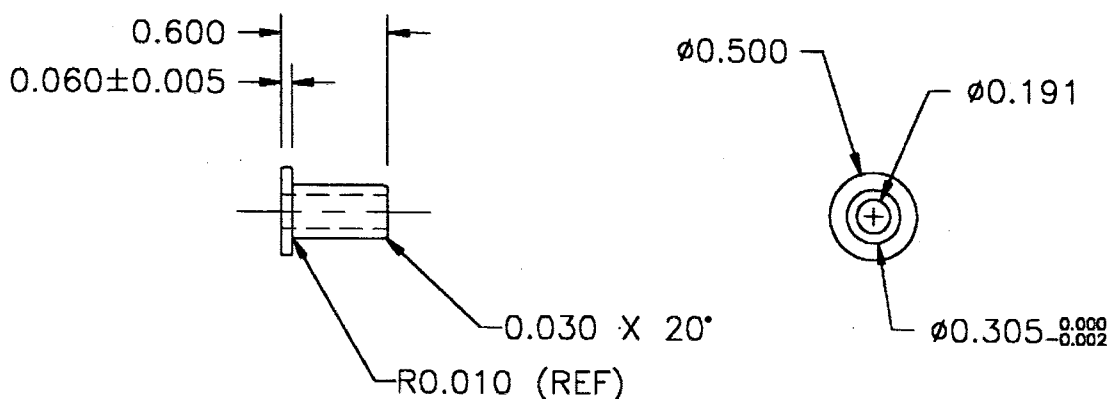
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART. QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries